

Date: Thursday, 19/06/2008 9:53:40 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SEAL
Job Number	: 39950		
Estimate Number	: 13074		
P.O. Number	:	Part Number	: D36507
This Issue	: 19/06/2008 S.O. No. :	Drawing Number	: D3650 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 35924	Material	:
Written By	:	Due Date	: 30/06/2008 Qty: 2 Um: Each
Checked & Approved By	: <u>JUL 08.6.19</u>		
Comment	: Est Rev:A New Issue 07-11-19 DD verified by: EC Est Rev:B ecn1162 08-04-02 DD verified by: EC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Cut 8168-1 seal 8.19" long as per dwg D3650

FF 08-07-16 (3)

2.0

81681

SEAL



Comment: Qty.: 0.7350 f(s)/Unit Total : 1.4700 f(s)

SEAL

batch: M106312

FF 08-07-16 (2)

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/16 (43)

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 08/07/16 (3)

5.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/17

Job Completion



MF 08-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

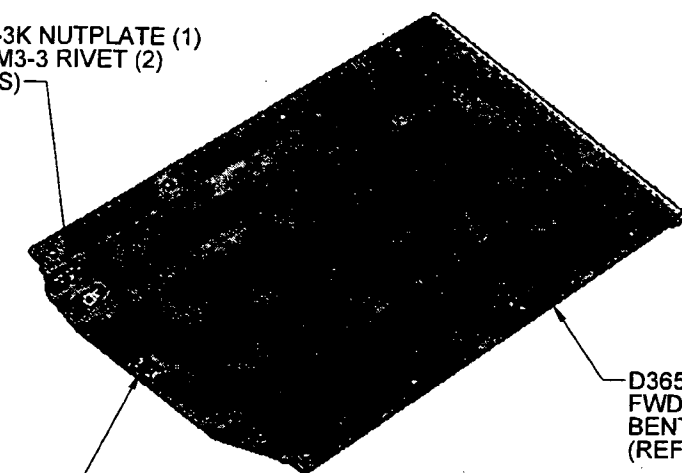
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

MS21062-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(2 PLACES)



MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(2 PLACES)

B

PART LIST

QTY	PART NUMBER	DESCRIPTION
X	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
12	AN960C4	WASHER
12	CR3523-4-03 or NAS9307M-4-03	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE

B

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.8 lbs

AN960C4 WASHER (REF)

0.07

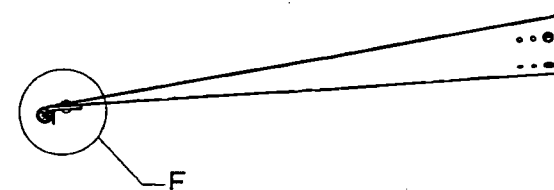
0.74

D3650-5B FWD PANEL BENT PART (REF)

D3650-7-8.19 SEAL (1)
D3650-9 ANGLE (1)

CR3523-4-03 OR (NAS9307M-4-03) RIVET (REF)

DETAIL F



F

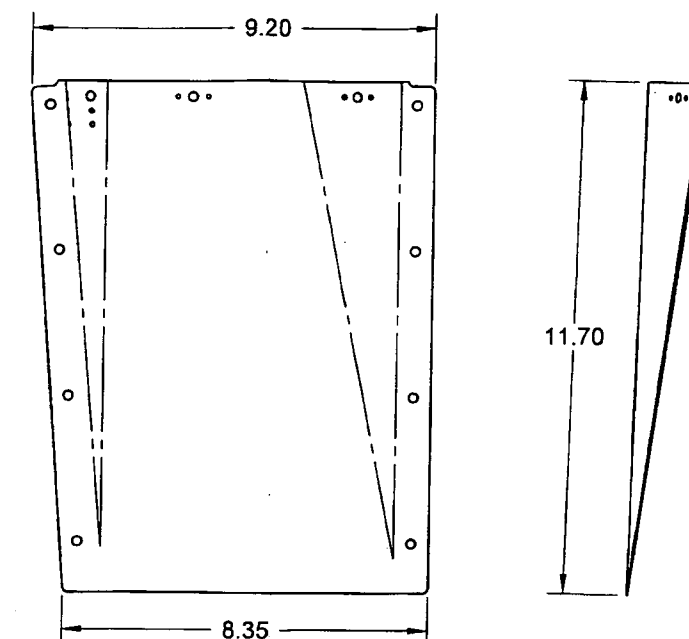
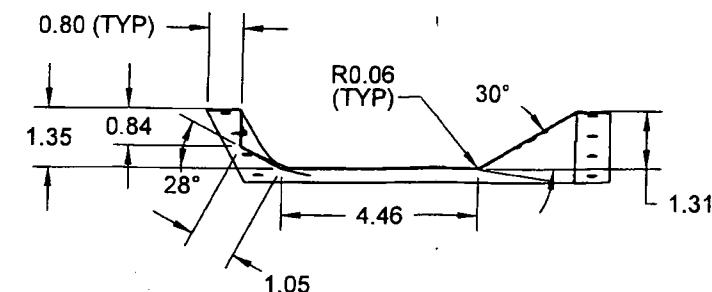
D3650-9 (REF)

D3650-7-8.19 (REF)

D3650-5B FWD PANEL BENT PART

CENTRE D3650-7-9 ON D3650-5B & TRANSFER $\varnothing 0.129$ (#30 DRILL) HOLES FROM D3650-9 TO D3650-7 & D3650-5B AS SHOWN
INSTALL
CR3523-4-03 OR NAS9307M-4-03 RIVET (1)
AN960C4 WASHER (1)
(12 PLACES)

D3650-5 FWD PANEL



D3650-5B FWD PANEL BENT PART (MAKE FROM D3650-5F FLAT PATTERN)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38930

RELEASED
08 03 27 / WP

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	MP	D3650	SHEET 7 OF 9
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	TOP PANEL ASSEMBLY	1:4
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	